

Date: Tuesday, 01/05/2007 2:22:17 PM  
User: Linda Lucelle

## Process Sheet

*split*  
*SB 07/05/09*

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : GUIDE ASS'Y
Job Number : 31913 <i>-2</i>	
Estimate Number : 12706	
P.O. Number : <i>NIA</i>	Part Number : D35725
This Issue : 01/05/2007 S.O. No. : <i>NIA</i>	Drawing Number : D3572 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>NA</i>	Drawing Revision : B
Previous Run : 31913	Material : <i>NIA</i>
Written By : <i>[Signature]</i>	Due Date : 13/05/2007
Checked & Approved By : <i>[Signature]</i>	Qty: <i>63</i> Um: Each
Comment : Est Rev : A New Issue 07-01-16 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S080	6061-T6 .080 Sheet
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Comment: Qty.: 0.0315 sf(s)/Unit Total: 1.8900 sf(s)

6061-T6 .080 Sheet

Batch: *M104186*

*SAD 07/05/04*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3572

Dwg Rev: *B*

Prog Rev: *B*

*SAD 07/05/04*

*[Signature] 07/05/07*

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*SAD 07/05/04*

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*SA 07/05/04*

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

form bend as per Dwg D3572 usin DT8943

*SB 07/05/09* *(24)*



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/05/09	5	split w/o	SB	07/05/09	34	 07.05.10	 07.05.10

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GUIDE ASSY

Job Number: 31913

Part Number: D35725

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*7/05/10 (24)*

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *57108**Pc 7/15/11 (24)*

8.0

QC21

FINAL INSPECTION/W/O RELEASE

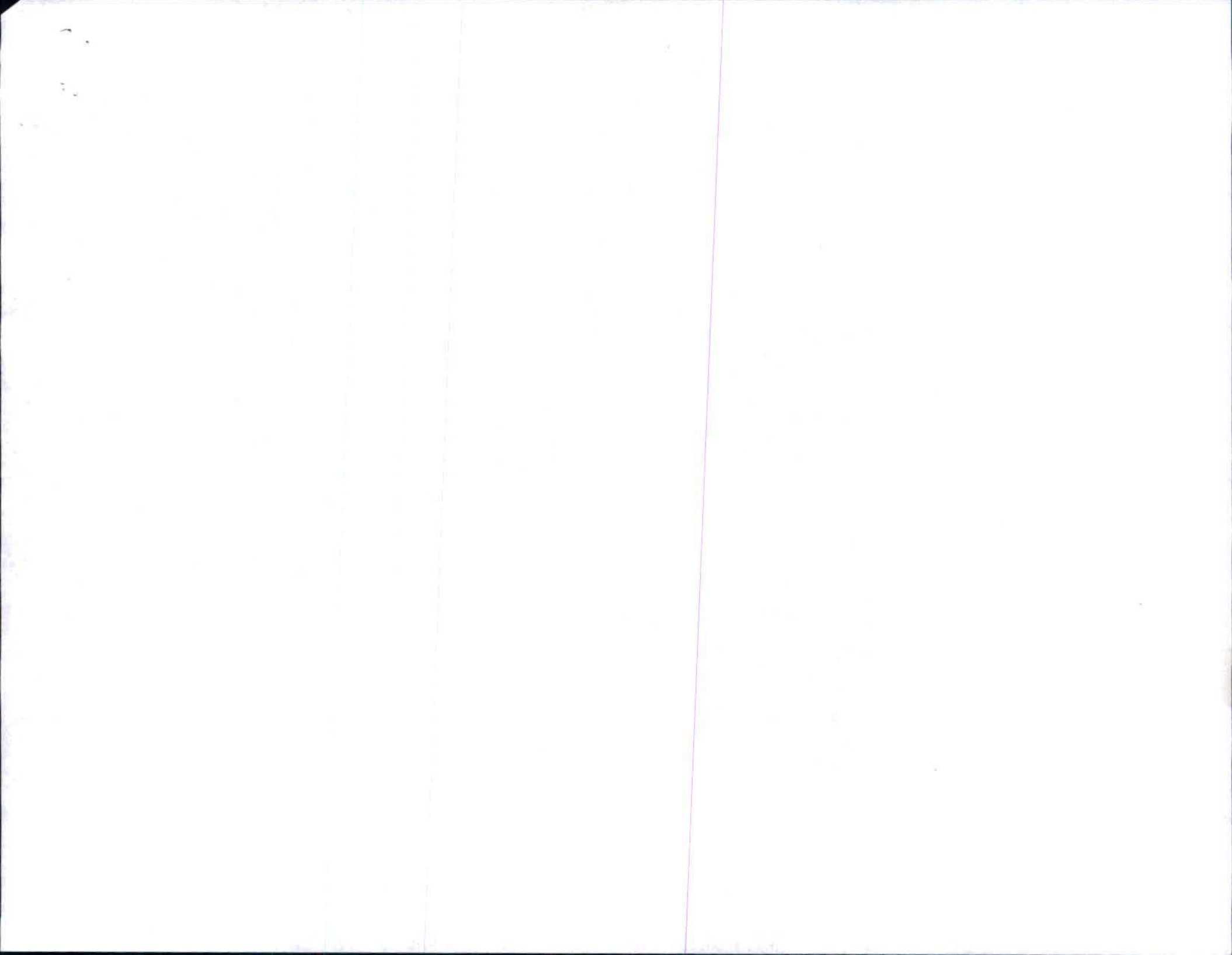


Comment: FINAL INSPECTION/W/O RELEASE

*(24)**7/05/15*

Job Completion

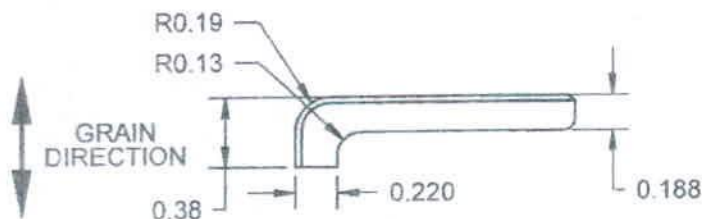
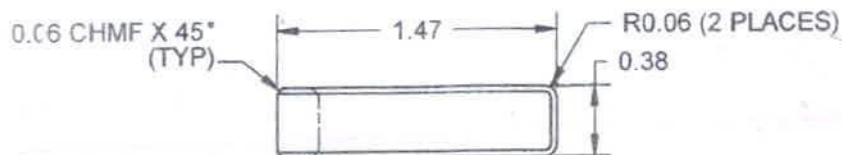
*12 7/05/15*







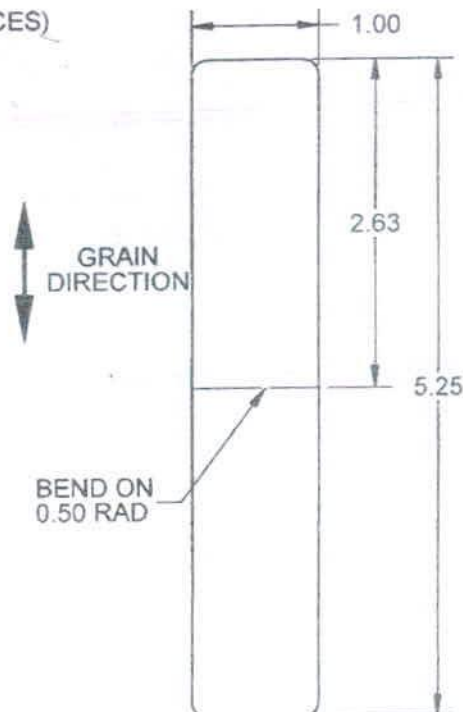
DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3572</b>	REV. A SHEET 2 OF 2
DATE <b>07.03.29</b>		TITLE <b>GUIDE ASSEMBLY</b>	SCALE 2:3



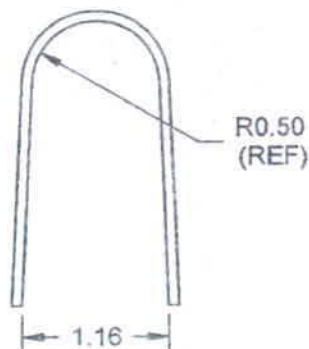
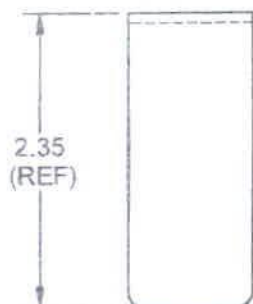
**1 D3572-3 GUIDE**

RELEASED

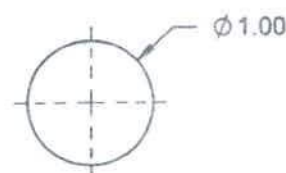
07.04.12 *[Signature]*



**2 D3572-5F FLAT PATTERN**



**D3572-5 BRACKET  
(MAKE FROM D3572-5F)**



**2 D3572-7 CAP**

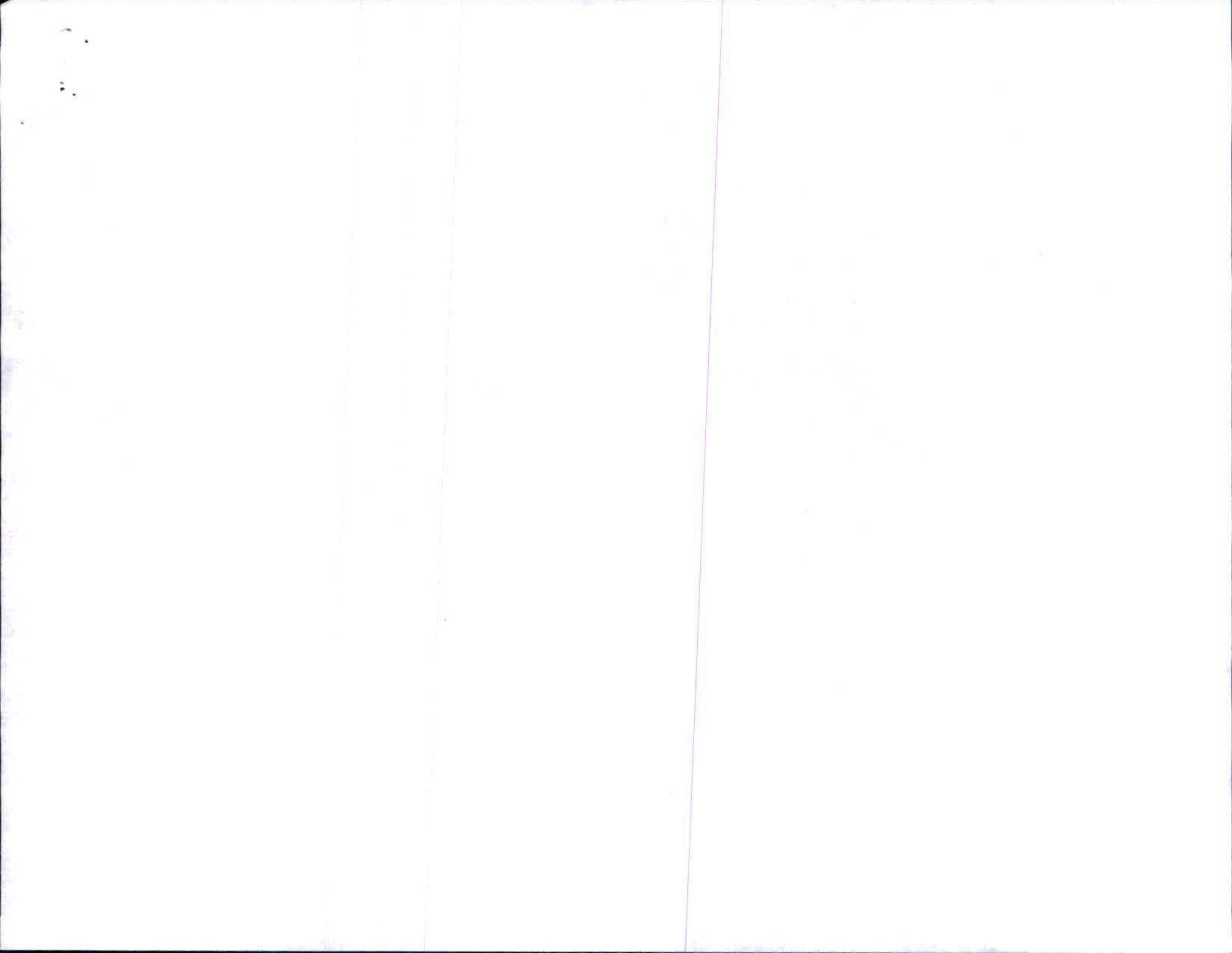
SHOP COPY  
RETURN TO  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. \_\_\_\_\_

**D3572-3/-5/-7 NOTES:**

- 1) D3572-3 MATERIAL: 6061-T6 (OR T651/T6510/T651/T62) ALUMINUM BAR PER QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 (OR AMS 4160) (REF DART SPEC M6061T6B)
- 2) D3572-5/-7 MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK PER QQ-A-250/11 OR AMS 4025 OR 4027 (REF DART SPEC M6061T6S.080)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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SPACE-IT®

Work Order: 31913

Guide Nov 41

ser. 40000 D35725

D3572 36 B

## FIRST ARTICLE INSPECTION CHECKLIST

1st Article ☒ Prototype

Specimen	Test	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection
1.00		$\pm 0.030$	1.01	✓		vern
5.25		$\pm 0.030$	5.26	✓		vern
0.080		$\pm 0.010$	0.076	✓		vern
67727	Direction	↕		✓		

SAD

07/05/04

by: Agnes C. W.

47 6834

Change

